

Work Order ID 137609

137609

Page 1

Wednesday, October 07, 2015 12:40:57 PM

Item ID: D135-692-011

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Bearpaw

Start Date: 9/25/15 Start Qty: 2.00

2 3 **3**
2 3

Cust Item ID:

Required Date: 10/07/15 Req'd Qty: 2.00

Customer:

Reference:

Approvals: Process Plan: MLS Date: OCT 03 2015 Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D3049	A1
IIN-D135-692	B

100	Document Control	0.00	DAS 6 9-89						
100	DOCUMENT CONTROL								
DC	Memo	0.00							
Doc.Control -USB or Paperwork	Photocopy bluefile and create labels per PPP D135-692-011		CHG002						

MLS 15-12-09 **3**

3X DAS
27
9-89

DEC 16 2015

150	Pick Kit	0.00							
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150									
Packaging	Memo	0.00							
Packaging									

DAS
6
9-89

DAS
28
9-89

DEC 08 2015

DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					

Root Cause				FAULT CATEGORY			
Environment ☐		No Re-verification ☐		Pressure/Forced ☐		Temperature/Cure ☐	
Design ☐		Operator ☐		Bending ☐		Set-up ☐	
Doc/Data ☐		Offset/Setup ☐		Centre Not Concentric ☐		BOM/Route ☐	
Equip/Tooling ☐		Supplier ☐		Cracks ☐		Broken/Damage/Defect ☐	
Handling/Pre ☐		Training ☐		Crimp/Kink/Ripple/Wave ☐		Inspection Incomplete/Unqualified ☐	
Material ☐		Use for Testing ☐		Cuffs ☐		Contamination ☐	
Internal Transport ☐		Poor Information ☐		Crushing ☐		Countersink ☐	
Tribal Knowledge ☐		Rushing ☐		Heat Treat ☐		Cut Too Short ☐	
LOA ☐		Product Improvement ☐		Wave/Twist in Tube ☐		Instructions Incomplete/Unclear ☐	
Substation ☐		Process Improvement ☐		Marks/Chatter ☐		Drill Holes ☐	
Past Expiry Date ☐		Manufacturing Process ☐		OTHER : ☐			
Misidentified ☐		Past Due ☐					

Work Order ID 137609

137609

Page 2

Wednesday, October 07, 2015 12:40:57 PM

Item ID: D135-692-011 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Bearpaw
 Start Date: 9/25/15 Start Qty: 2.00 ***2*** Cust Item ID:
 Required Date: 10/07/15 Req'd Qty: 2.00 ***2*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	QC4- 100% Inspect kits for completeness	0.00							
160									
QC	Memo	0.00							
Quality Control									
170	Packaging	0.00							
170									
Packaging	Memo	0.00							
Packaging	Identify and pack for shipping as per PPP D135-692-011								
	Location: <u>FGC13</u>								
	PPP Rev: _____								
180	QC21- Final Inspection - Work Order Release	0.00							
180									
QC	Memo	0.00							
Quality Control									

3X BAS
27
9-89
DEC 16 2015

3X BAS
27
9-89
DEC 16 2015

MCS DEC 18 2015

SHA 0151214

DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="width:15%;">Skid-tube ☐</td> <td style="width:15%;">Cross tube ☐</td> <td style="width:15%;">Water Jet ☐</td> <td style="width:15%;">Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐																																							
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OTHER : ☐																																																															

Picklist Print

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Work Order ID: 137609

137609

Parent Item: D135-692-011

D135-692-011

Parent Item Name: Bearpaw

Start Date: 9/25/15

Required Date: 10/07/15

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP Rev:C04.02.17Blank size changed, Tolerance added Step
3KJ/JLM IPP REV:E AS PER DSI
9592/9587 REV A JLM VERIFIED BY:EC
IPP Rev:D 08-04-16 Added Step 2 JLM Verified By:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

AN4-13A		Purchased	No				Each	362.0000	8	1624			
AN4-13A									**	133769			
Bolt													

BAS
27
9-89
X3

Location	Loc Qty	Loc Code
FG	20	
122808	20	
ST325A	200	
m133284	100	
m133323	100	
ST344	142	
m132551	142	

DAS
28
9-89

D2182B		Manufactured	No			160	f	618.9283	2	46			
D2182B									**				

Rubber Cushion - Black (\$Per Foot)

4 x 060
BAS
27
9-89
X3

Location	Loc Qty	Loc Code
ST411	618.9283	
130427	268.9283	
135093	350	

DAS
28
9-89

D2274		Manufactured	No			160	Each	52.0000	8	1624			
D2274									**	136201			

Radius Block

BAS
27
9-89
X3

Location	Loc Qty	Loc Code
FG	12	
86855	12	
ST006	40	
134217	40	

DEC 08 2015
DAS
28
9-89

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					

Root Cause				FAULT CATEGORY							
Environment	☐	Design	☐	Pressure/Forced	☐	Temperature/Cure	☐	Power Loss/Surge	☐	Positioned Wrong	☐
			☐ No Re-verification						☐ Folio/Program		☐ Outside Dimensions
			☐ Operator		☐ Bending		☐ Set-up		☐ Grain		☐ Over/Under tolerance
			☐ Offset/Setup		☐ Centre Not Concentric		☐ BOM/Route		☐ Weld		☐ Part Incorrect
			☐ Supplier		☐ Cracks		☐ Broken/Damage/Defect		☐ Wrong Stock Pulled		☐ Part Lost/Missing
			☐ Training		☐ Crimp/Kink/Ripple/Wave		☐ Inspection Incomplete/Unqualified		☐ Out of Sequence		☐ Part Moved
			☐ Use for Testing		☐ Cuffs		☐ Contamination		☐ Off-set		☐ Drawing
			☐ Poor Information		☐ Crushing		☐ Countersink		☐ Mislabeled		☐ Finish
			☐ Rushing		☐ Heat Treat		☐ Cut Too Short		☐ Fit/Function		☐ Misread
			☐ Product Improvement		☐ Wave/Twist in Tube		☐ Instructions Incomplete/Unclear		☐ Misaligned/off center		☐ Turning Sequence
			☐ Process Improvement		☐ Marks/Chatter		☐ Drill Holes				
			☐ Manufacturing Process	OTHER :							
			☐ Past Due								

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Work Order ID: 137609

137609

Parent Item: D135-692-011

D135-692-011

Parent Item Name: Bearpaw

Start Date: 9/25/15

Required Date: 10/07/15

Start Qty: 2.00

Required Qty: 2.00

D2519

Manufactured No

160

Each

38.0000

4

8 1/2

**

DAS
28
9-89

D2519

Clamp

Location

Loc Qty

Loc Code

ST542

38

137051

38

12

D2529

Manufactured No

160

Each

271.0000

8

16 24

**

DAS
28
9-89

D2529

Washer

Location

Loc Qty

Loc Code

ST007

71

131945

71

ST008

200

135846

100

136774

100

DEC 08 2015

D3049-1

Manufactured No

160

Each

0.0000

2

4 1/2

**

DAS
28
9-89

D3049-1

Bearpaw

138234
10/12/16

DAS
27
9-89

DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: _____ Date: _____

Work Order update only ☐

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Work Order ID: 137609

137609

Parent Item: D135-692-011

D135-692-011

Parent Item Name: Bearpaw

Start Date: 9/25/15

Required Date: 10/07/15

Start Qty: 2.00

Required Qty: 2.00

MS21042L4

Purchased No

160

Each

1,327.000

8

T624

MS21042L4

Locknut

133363

DEC 08 2015

DAS
28
9-89

DAS
27
9-89

X3

Location

Loc Qty

Loc Code

FP001

2

m124231

2

GA

112

m127813

112

ST260a

170

m130799

56

m131803

6

m132262

108

ST305

1043

m128300

8

m130388

7

m130922

97

m131618

12

m132123

56

m132382

763

m133316

100

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

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Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐							
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Parent Item: D135-692-011

D135-692-011

Parent Item Name: Bearpaw

Start Date: 9/25/15

Required Date: 10/07/15

Start Qty: 2.00

Required Qty: 2.00

NAS1149D0463J

Purchased

No

160

Each

5,688.000

8

1624

NAS1149D0463.I

WASHER

**

DAS

6

9-89

DAS

28

9-89

Location

Loc Qty

Loc Code

GA

41

M129390

41

ST260a

3500

M133284

2000

M133316

1500

ST269

2147

M129682

62

M130799

371

M132317

101

M132677

888

M133077

725

BAS
27
9-89

X3

QS100-M24S

Purchased

No

160

Each

11.0000

4

8412

QS100-M24S

Clamp

**

M133363

DAS

6

9-89

DAS

28

9-89

Location

Loc Qty

Loc Code

ST544

11

m133134

3

m133234

8

BAS
27
9-89

X3

DEC 08 2015

DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: _____ Date: _____

Work Order update only ☐

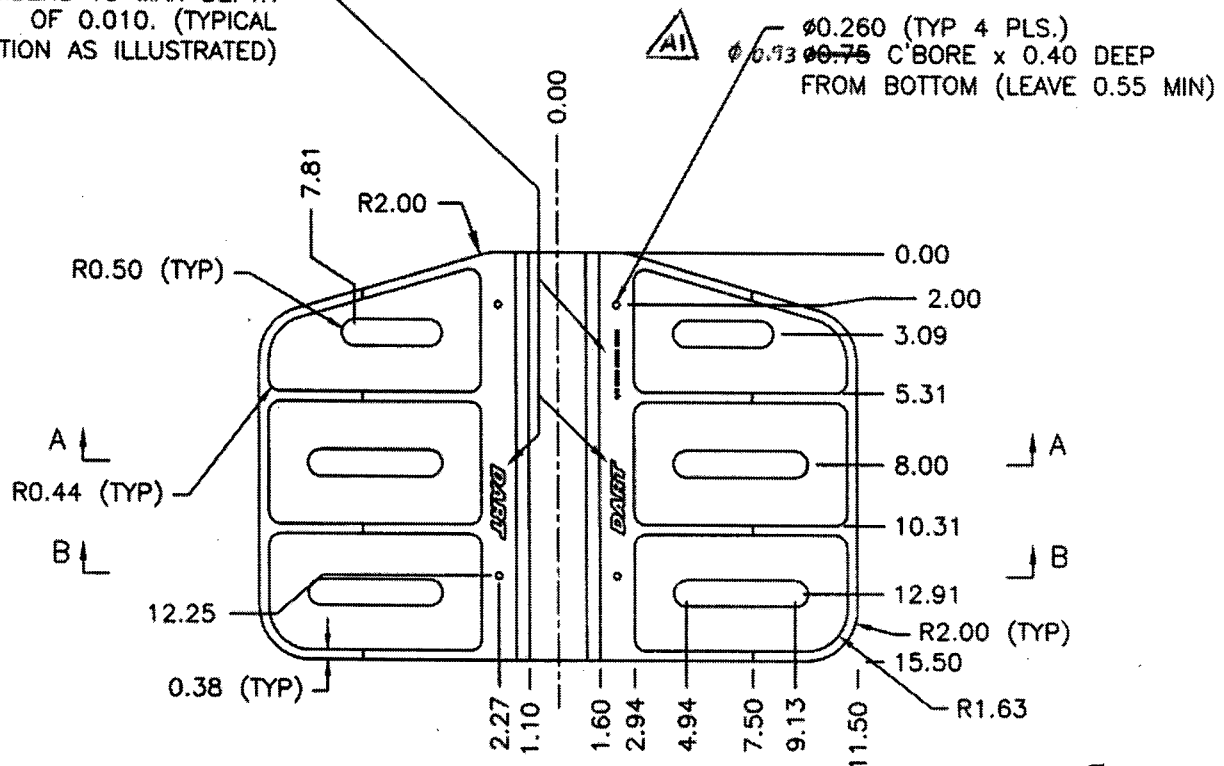
Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐							
		OTHER : ☐							



DESIGN RF	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D3049	REV. A SHEET 1 OF 2
DATE 01 10.18		TITLE BEARPAW	SCALE 1:7
A	01.10.18	NEW ISSUE	
AI	# RF 03.01.13	Ø 0.93 WAS Ø 0.75	

RELEASED
01.10.24

ENGRAVE DART LOGO TO
MAX DEPTH OF 0.012.
ENGRAVE PART AND BATCH
NUMBERS TO MAX DEPTH
OF 0.010. (TYPICAL
LOCATION AS ILLUSTRATED)



D3049-1 BEARPAW

NOTES:

- 1) BEARPAW IS SYMMETRIC ABOUT CENTER LINE
- 2) MATERIAL: UHMW BLACK PER SPEC CONTROL DRAWING D2689, 1.00" THICK (MACHINE TO 0.950)

SHOP COPY
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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO 137609 MJS
15-10-08

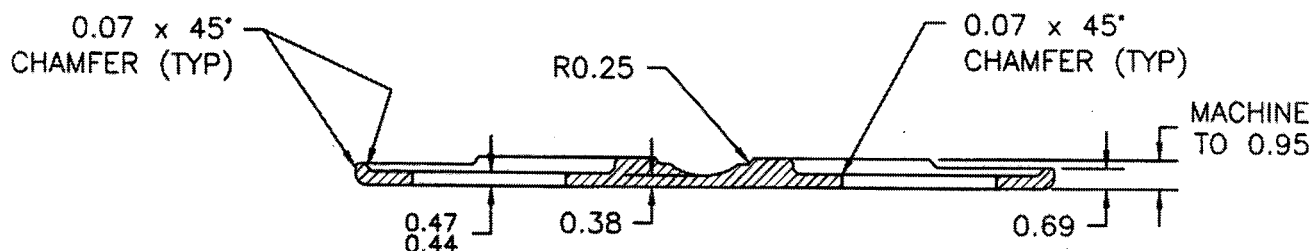
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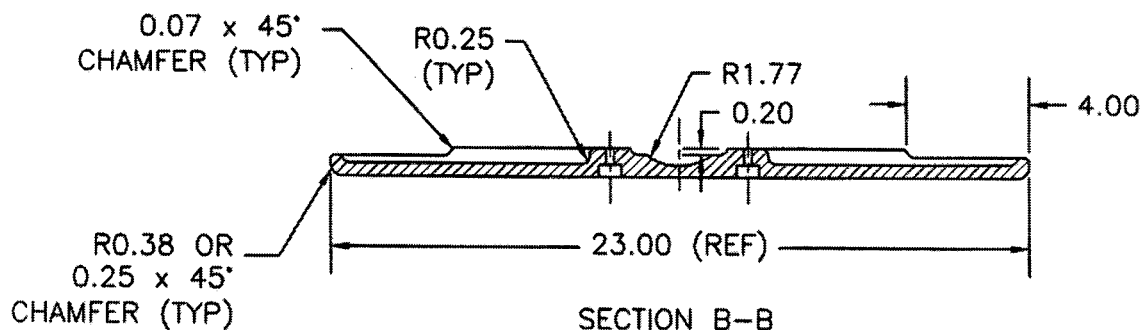


DESIGN RF	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED 	APPROVED 	DRAWING NO. D3049	REV. A SHEET 2 OF 2
DATE 01.10.18		TITLE BEARPAW	SCALE 1:6

RELEASED
01.10.24



SECTION A-A



SECTION B-B

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4. WEIGHT AND BALANCE

Installation	Weight	LATERAL		LONGITUDINAL	
		Arm	Moment	Arm	Moment
D135-692-011 <i>Bearpaw Installation</i>	11.8 lb 5.36 kg	0.0 in 0.0 m	0.0 in-lb 0.0 m-kg	199.7 in 5.07 m	2356 in-lb 27.2 m-kg
D135-692-041 <i>Wearplate Kit</i>	2.24 lb 1.0 kg	0.0 in 0.0 m	0.0 in-lb 0.0 m-kg	199.7 in 5.07 m	447 in-lb 5.1 m-kg
D135-692-011 <i>Bearpaw Installation, Aft Location</i>	11.8 lb 5.36 kg	0.0 in 0.0 m	0.0 in-lb 0.0 m-kg	201 in 5.10 m	2372 in-lb 27.3 m-kg
D135-692-041 <i>Wearplate Kit, Aft Location</i>	2.24 lb 1.0 kg	0.0 in 0.0 m	0.0 in-lb 0.0 m-kg	201 in 5.10 m	450 in-lb 5.1 m-kg

5. PARTS LIST

Qty -011	Qty -041	Part Number	Description
X		D135-692-011	BEARPAW INSTALLATION
	X	D135-692-041	WEARPLATE KIT
4		D2182B060	RUBBER CUSHION
8		D2274	RADIUS BLOCK
2		D3049-1	BEARPAW
8		D2529	WASHER
4		D2519	CLAMP
	2	D3719-041	WEARPLATE
8	8	AN4-13A	BOLT
8	8	NAS1149D0463J	WASHERS
8	8	MS21042L4	NUT (OR MS21042-4)
4		QS100M24S	CLAMP